Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.4111
Job Sheet 202882

Part No: 647.4111
Part Name: Doubler
Job Qty: 12 pcs

Part Weight: 0 lbs
Job Created: 11/5/19
Due Date: 12/18/19
Type: ~~Stock~~ SOLD 1 of 2

Status: New
Job Tracking No:
Created By: Marie Lajeunesse
Description:

Priority: Medium

Note: DWG REV N/C3 SHEET 2 IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier: Workcenter / Supplier	Lead Time	Sign-off
110	Waterjet - Flow - 1	12 pcs		12/18/19	0.17	0.92	Waterjet - Flow		JRB 12/4/19
120	QC 2	12 pcs		12/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

PRIORITY

DART AEROSPACE
Container No: S237307
Part: 647.4111
Job No: 202882
Serial No/Batch: S237307
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 12/04/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	JRB 12/4/19
125	**Small Fab - 2 - B4B**	12 pcs	12/18/19	0.00 5.25	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	DAS 58 9-89 DEC 05 2019
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
130	**QC 8**	12 pcs	12/18/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	DAS
					QC 8 - 40	DEC 06 2019 40 9-89
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	**Outsource - 4 - Anodize**	12 pcs	12/18/19		ATG001-VC 10	2019-12-11
150	**Packaging 2-1 - Receive - B4B**	12 pcs	12/18/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	JAN 07 2020

				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
160 **QC 6**	12 pcs	12/18/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS
				QC 6 - 40	JAN 0 7 2020 40 9-89
				QC 6 - 81	
190 **Packaging 3-1 - Stock - B4B**	12 ✓ pcs	12/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	DAS
				Packaging 3 - 3 - B4B ✓	cck112 80 9-89
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	JAN 0 8 2020
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	

					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - **B4B**	
					Packaging 3 - 36 - B4B	
200 **QC 21 - SA**	12 ✓ pcs	12/18/19	0.00 0.00	QC 21 - SA - 21 ✓		CCK112
				QC 21 - SA - 70	DAS	
				QC 21 - SA - 53	21	JAN 0 8 2020

Part Op **110** - 1-Cut as per Dwg Dwg Rev: N/3 Prog Rev: N/3

Descriptions: **120** - (QC2- Inspect parts off machine FAI/FAIB)
125 - (Small Fab) 1-DRILL HOLES USING DT10080 (647.4111 DRILL TEMPLATE) 2-Deburr if necessary
130 - (QC8- Inspect parts - second check)
140 - ANODIZE TEMPLATE Issue P/O to ATG: 45374 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Comformity is required
150 - (Receive & Inspect for Damage & Mat'l Certs)
160 - (QC6- All purchased or subcontracted products)
190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.7376 sf (.1448 ea)	110-Waterjet - Flow - 1	5191572

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.040	2	231	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.094inches + 0.004 - 0.001	0.098 0.093		Diameter
2	Doubler	0.052inches + 0.004 - 0.001	0.056 0.051		Diameter
3	Doubler	1.031inches ± 0.010	1.041 1.021		
4	Doubler	1.375inches ± 0.010	1.385 1.365		
5	Doubler	1.719inches ± 0.010	1.729 1.709		
6	Doubler	2.281inches ± 0.010	2.291 2.271		
7	Doubler	2.625inches ± 0.010	2.635 2.615		
8	Doubler	2.969inches ± 0.010	2.979 2.959		
9	Doubler	4.281inches ± 0.010	4.291 4.271		
10	Doubler	4.625inches ± 0.010	4.635 4.615		
11	Doubler	4.969inches ± 0.010	4.979 4.959		
12	Doubler	5.534inches ± 0.010	5.544 5.524		
13	Doubler	5.875inches ± 0.010	5.885 5.865		
14	Doubler	6.219inches ± 0.010	6.229 6.209		
15	Doubler	0.813inches ± 0.010	0.823 0.803		
16	Doubler	1.438inches ± 0.010	1.448 1.428		
17	Doubler	2.063inches ± 0.010	2.073 **2.053**		

Plex 11/5/19 9:19 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	

Other/Details:

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045374

Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045374
PO Date: 12/11/19
Due Date: 12/19/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

2019 12 12

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202885	647.4115	647.4100 Rev N/C3	Shim : Various STC's (Outsource **process-Anodize** per QSI017 4.1.10.1) Issue P/O _____ ATG, black anodize and prime as per dwg 647.4115 Rev. N/C	Firmed	-	12/19/19	24 pcs	0 pcs	24 pcs	$9.22/pcs	$221.28
2	202882	647.4111	647.4100 Rev N/C3	Doubler : Various STC's ANODIZE TEMPLATE Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Comformity is required	Firmed	-	12/19/19	12 pcs	0 pcs	12 pcs	$10.87/pcs	$130.44

X24

X12

JAN 07 2020

JAN 07 2020

DAS
40
3-89

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045374

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	202878	RBW0905G01652-3G	RBW0905G01652-3G Rev A	Tongue Shear Bolt (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/19/19	11 pcs	0 pcs	11 pcs	$14.27/pcs	$156.97

DEC 1 8 2019

Grand Total: $508.69

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/19 3:44 PM Dart.Guerin.Kimberley

A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 919306 Date: 23-Dec-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery

Quantity	Description
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.
24 ea	Part: 647.4115 Rev: N/C Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# S236137 Expiry Date: 05/29/2021 Job: 26596 Line: 1 PO: POIHB045374
12 ea	Part: 647.4111 Rev: N/C Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot# S236137 Expiry Date: 05/29/2021 Job: 26597 Line: 2 PO: POIHB045374
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: DEC 2 3 2019 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.

DA: 40 9-89

RECEIVED
JAN 0 6 2020
DART AEROSPACE LTD.

A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 919306 Date: 23-Dec-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery

Quantity	Description
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing **and it is suggested that they be** inspected within 24 hours of receipt.

Made in Canada.